

Date: Tuesday, 3/11/2008 7:57:23 AM
 User: Kim Johnston

Process Sheet

| | |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STRUT |
| Job Number : 37742 | |
| Estimate Number : 10200 | |
| P.O. Number : | Part Number : D21991 |
| This Issue : 3/11/2008 S.O. No. : | Drawing Number : D2199 REV. E1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 1 / Type : SMALL /MED FAB | Drawing Revision : E1 |
| Previous Run : 28996 | Material : |
| Written By : | Due Date : 3/25/2008 Qty: 4 Um: Each |
| Checked & Approved By : <u>AD 08 03 11</u> | |
| Comment : Est B 02.06.10 Added finish NG/RF | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.6275 f(s)/Unit Total : 6.5100 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall
 (M304TR0750W049)

Batch No:

M107245 SB 08/03/17 (4)

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: BRAKE NC

Punch per Dwg. D2199 and Spec Control Dwg D2638

SB 08/03/17 (4)

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

SB 08/03/18 (4)

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/18 (4)

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107005 (4)

| | | |
|-----|-----|---|
| 6.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT

M-1 08/03/14 (4X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 21/03/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 37742

Part Number: D21991

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 258

PC 8/3/19

(24)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/19

Job Completion



2008/3/19

(4)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

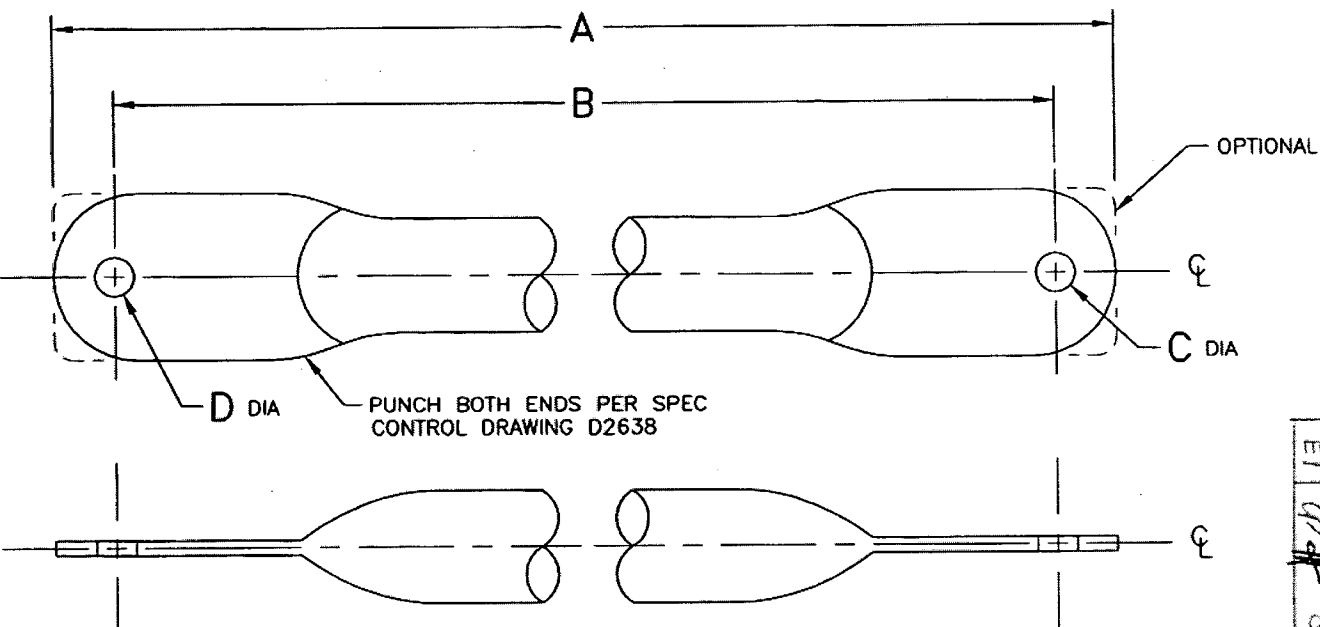
NOTE: Date & initial all entries

DARTDART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADAREV. E
SHEET 1 OF 1

| | | | | |
|----------|----------|-------------|---------------|-------|
| DESIGN | DRAWN BY | DRAWING NO. | TITLE | SCALE |
| CHECKED | APPROVED | D2199 | STRUT DETAILS | NTS |
| DATE | | | | |
| 98.04.28 | | | | |

RELEASED
98.04.05 KE

| | | |
|----|----------|---|
| A | 1993 | NEW ISSUE |
| B | | ADDED -11, -13, AND -15 |
| C | | ADDED -17 AND -19 |
| D | | ADDED -21 |
| E | 98.04.28 | ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD |
| E1 | 98.04.22 | ADD FINISH |



| | A | B | C | D |
|----------|-------|-------|-------|-------|
| D2199-1 | 18.30 | 17.50 | 0.257 | 0.257 |
| D2199-3 | 5.80 | 5.00 | 0.257 | 0.257 |
| D2199-5 | 22.64 | 21.84 | 0.257 | 0.316 |
| D2199-7 | 14.74 | 13.94 | 0.257 | 0.257 |
| D2199-9 | 16.52 | 15.72 | 0.257 | 0.257 |
| D2199-11 | 23.60 | 22.80 | 0.257 | 0.316 |
| D2199-13 | 15.96 | 15.16 | 0.257 | 0.257 |
| D2199-15 | 17.57 | 16.77 | 0.257 | 0.257 |
| D2199-17 | 28.05 | 27.25 | 0.257 | 0.316 |
| D2199-19 | 18.90 | 18.10 | 0.257 | 0.257 |
| D2199-21 | 10.80 | 10.00 | 0.257 | 0.257 |
| D2199-23 | 26.18 | 25.38 | 0.257 | 0.316 |
| D2199-25 | 19.93 | 19.13 | 0.257 | 0.257 |
| D2199-27 | 27.34 | 26.54 | 0.257 | 0.316 |
| D2199-29 | 21.11 | 20.31 | 0.257 | 0.257 |

B B B B B B B B B B

* 00.10.13
00.10.13**NOTES:**

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.750 \times 0.049$ WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART Q51 Q55 4.3/E1

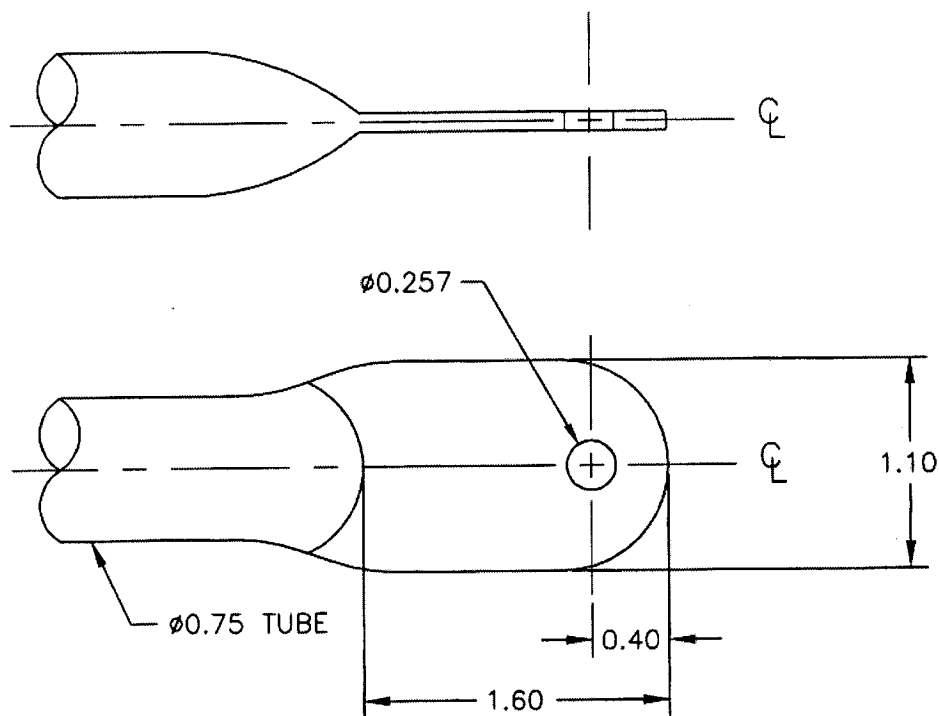
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WITHOUT NOTICE
WORK ORDER
NO. 37742



| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2638 | REV. A SHEET 1 OF 1 |
| DATE 98.04.28 | | TITLE PUNCH DT8117 SPEC CONTROL | SCALE 1:1 |
| A | 98.04.28 | NEW ISSUE | |

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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